

5

DART AEROSPACE LTD	Work Order:	18732
Description: Seal	Part Number:	D3117-3
Dwg: D3117 Rev. A	Qty:	500 540

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	JH	03.01.23	500
2	PG	Issue P/O: 2005069 D3117-3 Seal as per Dwg D3117 Possible Supplier: VIP Rubber Replace Premier P/N: B45-43000-03 Material release note required			
3	RG	Receive and inspect for transit damage Ensure material release note is attached	LL	03.01.23	500
4	QC6	Inspect dimensions as per Dwg D3117 and certification attached.	PR	03.01.23	540
5	PG	Issue P/O: 2005139 Cut Qty 3 sample 12" long of D3117-3 Send for testing to meet vertical burn test per F.A.R. 25.853 Possible testing site: Bodycote Materials Testing Canada Inc. Test report is required	LL	03.01.23	3 -
6	RG	Attach test report to W/O	LL	03.02.26	
7	ST	Identify and Stock	LL	03.02.26	540
8	AC	Cost / part 4.76	MM	03.02.27	540
9	DC	Close W/O 4.76 Inspect Level 21	LL	03.02.27	-

Rev	Date	Change	Revised By	Approved
A	03.01.22	New issue	KJ/RF	JH

RELEASED
03.01.23 RT

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector	
03.01.29	3	Received 10 ft sample. Dimensionally OK. Send 3 12" samples for Burn testing	U	03.01.29	3	MM 03.01.29	AB 03.02.29	

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

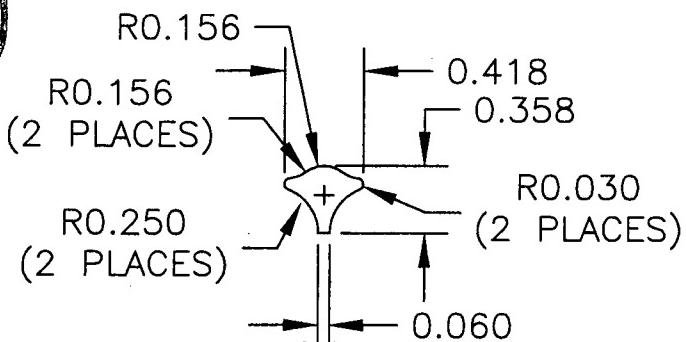
QA: N/C Closed: _____ Date: _____

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3117	SHEET 1 OF 1
DATE	TITLE	SCALE	1:1
02.04.15	SEAL		
A	02.04.15	NEW ISSUE	

RELEASED

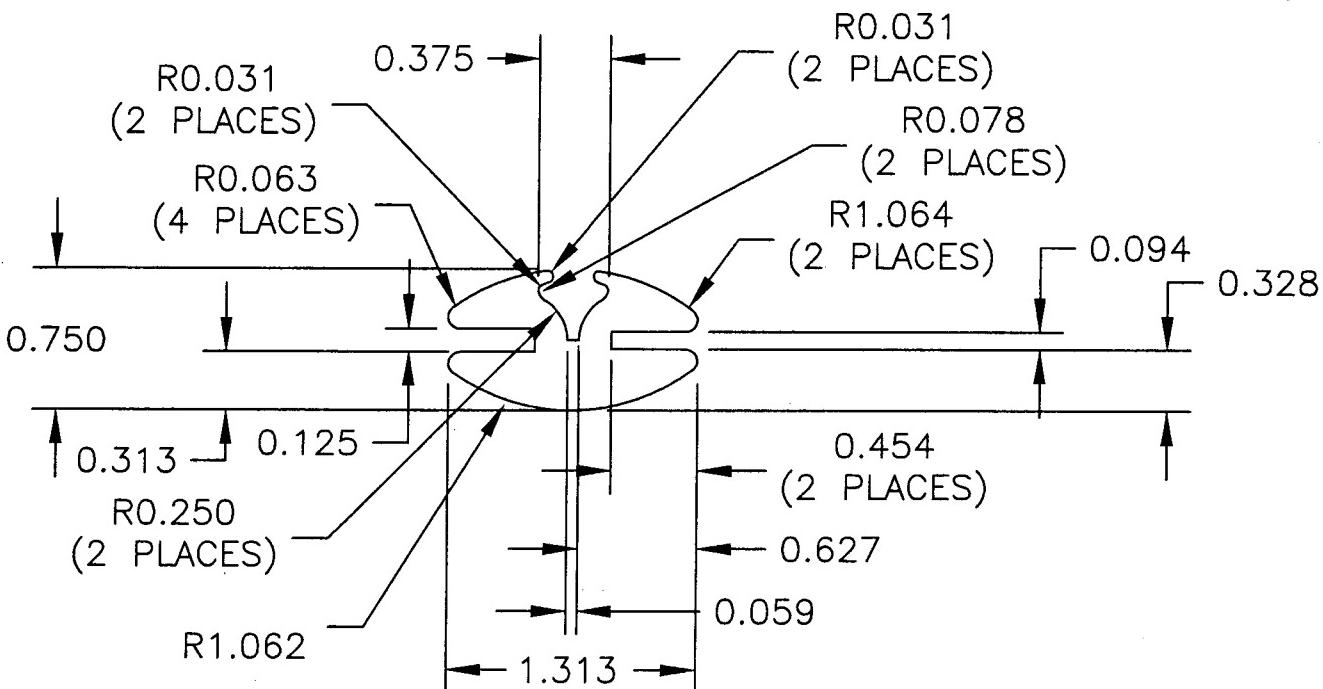
02.05.27



SHOP COPY

RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER
NO. 18732

D3117-3-XXXX SEAL FILLER
REPLACES PREMIER P/N B45-43000-03



D3117-1-XXXX SEAL RETAINER
REPLACES PREMIER P/N B45-43000-01

NOTES

- 1) MUST MEET BURN TEST PER F.A.R. 25.853
- 2) -XXXX = LENGTH IN INCHES (EG. 10" LONG = -0100, .875" LONG = -0875)
- 3) MATERIAL: BLACK RUBBER 60 DUROMETER (HARDNESS) NEOPRENE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 23, 2003
11:13 am

Work Order No	:	0018732	Department Code:	
Project Name	:	D3117-3	Burden Flags	: NNNNNNNN
Project For	:	WK305	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3117-3	Invoice Number	:
Description	:	Seal Filler	Invoice Amount	: 0.00
Manufactured	:	Yes	Order Entry No	:
Amount Req'd	:	500	OE Value	: 0.00
Amount Done	:	0	Est Margin	: 0.000%
Start Date	:	01-23-03	Actual Margin	: 0.000%
Est Finish Date	:	01-30-03	\$0 Posted to Finished Goods	
Act Finish Date	:			
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:			

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Testing Hours	: 0.00	0.00	0.00		
Testing Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
SubContract Hours	: 0.00	0.00	0.00		
SubContract	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

*Blue
Parker*
EXTRUDED AND MOLDED RUBBER • EXTRUDED PLASTIC
540 S. CYPRESS STREET, LA HABRA, CA 90631
(310) 905-3456 • (800) 722-4VIP
Fax: (310) 905-3450

CERTIFICATION
OF COMPLIANCE

RE-7107-1897-0156
DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY ONTARIO, CANADA
K6A1K7 613-632-9577

3644

ITEM NO.
RE-7107-1897-0156

CUSTOMER P.O.

2005069

DATE

1-7-03

SHIPPER NO.

19978

PART NO/DESCRIPTION

QUANTITY
ORDERED

MANUFACTURED IN CONFORMANCE WITH:
P/N B45-43000-01 REV. A SEAL RETAINER
P/N B45-43000-03 REV. A SEAL FILLER

CURE DATE

1Q03

SPECIFICATION 50/NEOPRENE MEETS F.A.R. 25.853 (P/N B45-43000-01)
50/NEOPRENE (P/N B45-43000-03)

THIS IS TO CERTIFY THAT
THE MATERIAL FURNISHED
ON THIS PURCHASE ORDER
WAS MADE IN STRICT
CONFORMANCE WITH THE
NOTED SPECIFICATION.

By

Martin Perez

MARTIN PEREZ
TECHNICAL DIRECTOR

VIP RUBBER COMPANY

DATE SHIPPED

2/24/03

QTY SHIPPED

540'
540'

Bodycote Materials Testing Canada Inc.

FAR 25.853(a) Vertical Flame Resistance of "Seal Filler D3117-3"

Page 1 of 1

For: Dart Aerospace Limited

Report No. 02-02-065(B)

ACCREDITATION Standards Council of Canada, Registration #1.**REGISTRATION** ISO 9002-1994, registered by QMI, Registration #001109.**SPECIFICATIONS OF ORDER**

Determine flame resistance in accordance with FAR 25.853(a), Amendment No. 25-83, Appendix F Part 1, Paragraph (a)(1)(ii), as per your Purchase Order No. 2005138 dated January 22, 2003.

CAVEAT

At the time of report issue, no specific aircraft, test program, or Confrmity Inspection Record was listed for inclusion in this report. Therefore, the results stated in this test report are limited to the test coupons supplied. However, if it is subsequently confirmed by the regulatory authority that the specimens tested were representative of the end-use product, the test results may be considered for certification purposes.

IDENTIFICATION (BMTC sample identification number 03-02-S0065-2)

Material identified as "Seal Filler, Part Number D3117-3", approximately 12.0" x 0.30" x 0.35" thick.

TEST RESULTS**FAR 25.853(a), Appendix F Part 1(a)(1)(ii)**

Vertical Bunsen Burner Test

12 s Flame Exposure Time

Actual component tested.

	Burn Length (in)	Flame Time (s)	Drip Flame Time (s)	Results (Pass / Fail)
Test #1	1.1	0.0	0.0	-
Test #2	1.3	0.0	0.0	-
Test #3	<u>1.2</u>	<u>0.0</u>	<u>0.0</u>	-
Average:	1.2	0.0	0.0	-
Specified Maxima:	8.0	15.0	5.0	Pass

CONCLUSIONS

The seal filler identified in this report meets the requirements of FAR 25.853(a), Amendment 25-83.

Anne-Lise Larsen,
Fire Testing Services.

Richard J. Lederle,
Fire Testing Services.

Note: This report consists of a cover page, plus 1 additional page that comprise the report "body". It should be considered incomplete if all pages are not present. Additionally, the Appendix of this report comprises a cover page, plus 1 page.

tions,
odycote Materials Testing Canada Inc.

FAR 25.853(a) Vertical Flame Resistance of "Seal Retainer D3117-1"

Page 1 of 1

For: Dart Aerospace Limited

Report No. 02-02-065(A)

ACCREDITATION Standards Council of Canada, Registration #1.

REGISTRATION ISO 9002-1994, registered by QMI, Registration #001109.

SPECIFICATIONS OF ORDER

Determine flame resistance in accordance with FAR 25.853(a), Amendment No. 25-83, Appendix F Part 1, Paragraph (a)(1)(ii), as per your Purchase Order No. 2005138 dated January 22, 2003.

CAVEAT

At the time of report issue, no specific aircraft, test program, or Confrmity Inspection Record was listed for inclusion in this report. Therefore, the results stated in this test report are limited to the test coupons supplied. However, if it is subsequently confirmed by the regulatory authority that the specimens tested were representative of the end-use product, the test results may be considered for certification purposes.

IDENTIFICATION (BMTC sample identification number 03-02-S0065-1)

Material identified as "Seal Retainer, Part Number D3117-1", approximately 12.0" x 1.25" x 0.75" thick.

TEST RESULTS

FAR 25.853(a), Appendix F Part 1(a)(1)(ii)

Vertical Bunsen Burner Test

12 s Flame Exposure Time

Actual component tested.

	Burn Length (in)	Flame Time (s)	Drip Flame Time (s)	Results (Pass / Fail)
Test #1	0.1	0.0	0.0	-
Test #2	0.1	0.0	0.0	-
Test #3	<u>0.1</u>	<u>0.0</u>	<u>0.0</u>	-
Average:	0.1	0.0	0.0	-
Specified Maxima:	8.0	15.0	5.0	Pass

CONCLUSIONS

The seal retainer identified in this report meets the requirements of FAR 25.853(a), Amendment 25-83.

Anne-Lise Larsen

Anne-Lise Larsen,
Fire Testing Services.

Richard J. Lederle
Richard J. Lederle,
Fire Testing Services.

Note: This report consists of a cover page, plus 1 additional page that comprise the report "body". It should be considered incomplete if all pages are not present. Additionally, the Appendix of this report comprises a cover page, plus 1 page.